

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025355**Date Inspected:** 20-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** William Sherwood**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) Field Splice welding at OBG 11W/12W
- 2) Submittal reviews at Pier 7

1)The QAI observed ABF personnel working at field splice 11W/12W welds A, B and F. The QAI noted that all work in being performed on the interior of the structure. The QAI noted that Quality Control Inspector (QCI) William Sherwood is monitoring this work. The QAI observed that at weld B, Jorge Lopez, ID 6149, is cleaning up the weld cover and grinding prior to visual inspection. At weld F, the QAI noted that the bottom transition to weld E is being welded by shielded metal arc welding (SMAW). The QAI also observed the QCI William Sherwood conducting magnetic particle testing (MT) on weld excavations for repairs in weld A. The QAI noted that all weld segments (A1 - A5) have repairs identified and are being excavated. This work was in progress at the end of the shift. See the attached photos.

While the QAI was monitoring the work at OBG 11W/12W, the QAI noted the locations of deck access holes, completed and not completed. The QAI recorded this information to verify with the tracking lists and weekly welding reports that are submitted by the contractor. The QAI noted that open deck holes are present at the following locations: PP13.5W1, PP29.5W1/E5, PP36.5W1, PP46.5W1/E5, PP61.5W1/E5, PP70.5W1/E1/E5, PP84.5W1/E5, PP109.5W1/W5/E1/E5 & PP116.5W1/W5/E1/E5.

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While the QAI was noting the locations of open deck access holes, the QAI observed two different electrode storage containers, one of which was a medium heated storage container, containing E7018H4R electrodes in uncontrolled atmospheric conditions. The QAI noted that these electrodes appear to have been exposed for periods exceeding the contract requirements. The QAI also noted that there are no welding operations in the areas where these electrodes are being stored. The QAI asked the QCI Jesse Cayabyab if he was aware of the storage of these electrodes. The QCI remarked that these electrodes have not been stored properly and will be disposed to prevent their use in contract welding. The QAI noted that the electrodes were disposed of.

2) The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP. The QAI completed reviewing submittal 1536R68 and generated a TL-20 report.



Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the observations of work and reviews to the QAI Joselito Lizardo and the QAI Lead Bill Levell. Except as described above, there were no other notable conversations or observations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
